

WHAT IS CLAIMED IS:

1. An adjustable pocket drilling fixture comprising:
 - a base, a clamping face on said base, said clamping face defining a plane;
 - a clamp body, a clamping face on said clamp body opposing said clamping face on said base;
 - clamping structure interengaging said clamp body and said base, said clamping structure including a clamp actuator positioned adjacent to said base to move said clamp body in a clamping direction;
 - a guide carrier, at least one drill guide in said guide carrier, said drill guide having an axis which intersects said plane of said clamping face on said base, said guide carrier being slidably mounted on said base to move in a direction substantially parallel to said plane.
2. The adjustable pocket drilling fixture of Claim 1, further comprising a gauging structure between said base and said guide carrier so that said guide carrier can be positioned at a predetermined distance from said base.
3. The adjustable pocket drilling fixture of Claim 2 wherein said gauging structure has a plurality of surfaces formed thereon, said gauging structure being movable with respect to said base so that one of said surfaces can be positioned to gauge the height of said guide carrier above said base.
4. The adjustable pocket drilling fixture of Claim 3 wherein said gauging structure comprises a turret.
5. The adjustable pocket drilling fixture of Claim 4, further comprising a detent interengaging between said turret and said base so that said turret is detented in its selected position.
6. The adjustable pocket drilling fixture of Claim 1 wherein said clamp actuator is on a same side as the guide carrier so that clamping and drilling the

workpiece can be accomplished on the same side.

7. The adjustable pocket drilling fixture of Claim 1, further comprising first and second clamp guide bars mounted on said base, wherein said clamp body is slidably mounted on said clamp guide bars, said clamp guide bars defining a plane that is substantially perpendicular to the plane of said clamping face on said base.

8. The adjustable pocket drilling fixture of Claim 7 wherein said clamping structure comprises a screw and a nut, said screw engaging in said nut, said clamp actuator being connected to rotate said screw with respect to said nut to adjust the distance between said clamping faces.

9. The adjustable pocket drilling fixture of Claim 1, further comprising at least one upright guide bar mounted on said base, wherein said guide carrier is mounted on said guide bar so that a movement of said guide carrier is in a direction substantially parallel to said clamping face.

10. The adjustable pocket drilling fixture of Claim 9 wherein said guide bar has height indicia so as to indicate the position of said guide carrier above said base.

11. The adjustable pocket drilling fixture of Claim 9, further comprising a quick engagement used to slidably couple said guide carrier to said base, wherein said quick engagement can be disengaged to slide said guide carrier with respect to said base, and engaged to fix a position of said guide carrier with respect to said base.

12. The adjustable pocket drilling fixture of claim 1, further comprising a carrier support mounted on said base, wherein said carrier support slidably engages said guide carrier in a direction substantially perpendicular to said clamping direction.

13. The adjustable pocket drilling fixture of Claim 12, further comprising a linear ratchet mechanism used to slidably engages said guide carrier to said carrier

support, wherein said linear ratchet mechanism can be unlocked to slide said guide carrier with respect to said carrier support, and locked to fix a position of said guide carrier with respect to said carrier support.

14. The adjustable pocket drilling fixture of claim 12, wherein said base has formed thereon at least one guide bar for slidably engaging said carrier support, and a turret, which can be rotated to adjust a position of the carrier support in a generally vertical direction, so as to adjust a height of said guide carrier, wherein said carrier support is slidable with respect to said base in a generally vertical direction.

15. The adjustable pocket drill fixture of claim 1, wherein said drill guide is replaceable.

16. The adjustable pocket drill fixture of claim 15, further comprising an insert disposed in said guide carrier for receiving said drill guide.

17. The adjustable pocket drill fixture of claim 11, wherein said quick engagement comprises a leaf spring for adjusting a vertical position of said guide carrier with respect to said base.

18. An adjustable pocket drilling fixture comprising:
a clamping face, said clamping face defining a plane;
a guide carrier, at least one drill guide in said guide carrier, said drill guide having an axis which intersects said plane of said clamping face; and,
at least an insert disposed in said guide carrier to receive said drill guide, said drill guide being replaceable.

19. An adjustable pocket drilling fixture comprising:
a clamping face, said clamping face defining a plane;
a guide carrier, at least one drill guide in said guide carrier, said drill guide having an axis which intersects said plane of said clamping face; and,
a bit disposed in said drill guide, said bit having indicia so as to

indicate drilling depth.

20. An adjustable pocket drilling fixture comprising:
 - a clamping face, said clamping face defining a plane;
 - a guide carrier, at least one drill guide in said guide carrier, said drill guide having an axis which intersects said plane of said clamping face; and,
 - at least an indicia pocket formed on the surface of drill guide entrance, which has a relationship to said the axis, wherein the width of said indicia pocket is substantially equal to an internal diameter of said drill guide.